	er ID 61684 t 31, 2010 11:48:31 AM										Page 1
Revision ID:	D3536-21 Gasket		Accept					Setup	Start Stop		
	8/31/2010 Start Qty: 6.00			Cust Item Customer:	ID:				·		
Approvals:	Process Plan:	Date:	Tooling: SPC (Y/N):		ate:		1	Run	Start Stop		
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr Rev A			,							
100 Waterjet FLOW CNC Waterje		per Dwg D3536 □Dwg Rev f necessary	0.00 /:□Prog Rev:_	A 🗆 2-			BU	<u>-9-</u> 0	1	(J))
QC Quality Control	QC2- Inspect parts of Memo	ff machine FAI/FAIB	0.00				R	(O-9-	1		
120 	QC8- Inspect parts -	second check	0.00				12				//1009

A1272

Quality Control

W/O:		······································	WO	RK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						<u> </u>			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DO	QA:	Date: _	
Resolution: Disposition:									
NCR:			WORK ORDI	ER NON-CONFORM	IANCE (NC	R)			
DATE	OTED	Description of NC		ction B	Veri	ication Approval		Approval	
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign Dat	& Sec	ction C	Chief Eng	QC Inspecto
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Work Order ID 61684

Tuesday, August 31, 2010 11:48:31 AM



Page 2

Item ID:

D3536-21

Accept

Setup Start

Stop



Revision ID:

Start Date:

Gasket **Item Name:**

8/31/2010

Start Qty: 6.00

Required Date: 9/7/2010 Req'd Qty: 6.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC: _____

Date:_____ Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Run

Stop

Start



Sequence ID/

Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00 0.00 **Tool ID**

Tool # Plan Code

Accept Qty

Reject Qty

Insp. Reject Number Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/07 A

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DATE	STEP	PRO	GE	Ву	Date (Approval Chief Eng / Prod Mgr	Approval QC Inspector					
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQA:	Date: _					
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DATE	STEP	Description of NC		Corrective Action Section		Verificat		Approval				
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Picklist Print

Tuesday, August 31, 2010 11:48:35 AM

Work Order ID: 61684

Parent Item: D3536-21

Parent Item Name: Gasket



Start Date: 8/31/2010

115500

Required Date: 9/7/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063	# 18 119111 BRIDE RIDE (111 489)	Purchased	No			100	sf	611.2133	0.8503	5.370316	(0.7	Š	vet
MEODRENE CHEET 0.002	# IM 318111 EBIID BIIEB IKII \$886						•			也	10-9-	.	

NEOPRENE SHEET 0.063

ocation		Loc Oty		Loc Code
ΛAΤ		505.9602	1	
•	114691	105.9602		
	115500	400		
/AT052		105.2531		
	114176	105.2531		



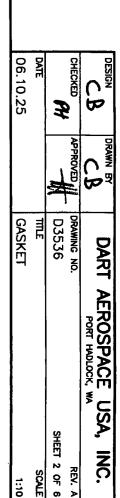
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DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	ction B	Sign &		cation	Approval	Approval
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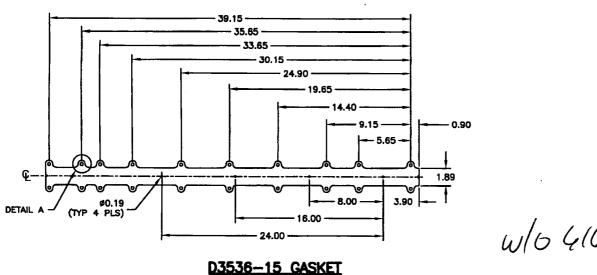
DART AEROSPACE LTD	Work Order:	41484
Description: Gasket	Part Number:	D3536-21
Inspection Dwg: D3536 Rev: A		Page 1 of 1

	FIRST	ARTICLE INSP	PECTION	CHECK	LIST	
	X	First Article		Prototyp	е	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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27.25	+/-0.030	27.25	>		T	
21.80	+/-0.030	08.16	Ø		τ	
16.35	+/-0.030	16.35	20		7	
10.90	+/-0.030	00.01	Ø		7	
5.45	+/-0.030	5,45	12		7	
24.00	+/-0.030	2400	4.		7	
16.00	+/-0.030	16,00	<i>y</i>		τ	
8.00	+/-0.030	8.00	½		τ	•
6.00	+/-0.030	6.00	8		T	
2.00	+/-0.030	7.000	×		N BOD.	
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1.89	+/-0.030	1.884	A		V	
Ø0.19	+0.004/-0.001	(190)	*		V	
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Measured by:	B	Audited by:		Pro	totype Approva	al: N/A
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Rev Date A 08.02.28	Change 3 New Issue				Revised KJ/DD a	by Approved

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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	CTED	Description of NC		Corrective Action Section			ication	Approval	Approval				
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DATE	OTED	Description of NC		Corrective Action Section		Verificat	ion	Approval	Approval
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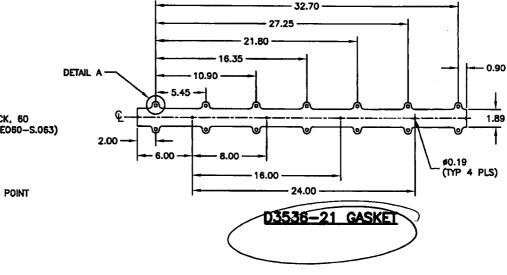
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07.02.12

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	MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063
2)	FINISH: NONE PART IS SYMMETRICAL ABOUT &
3)	PART IS SYMMETRICAL ABOUT €

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



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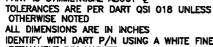




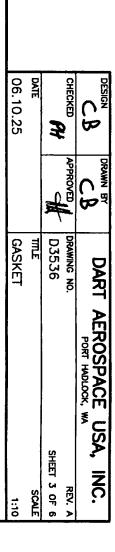


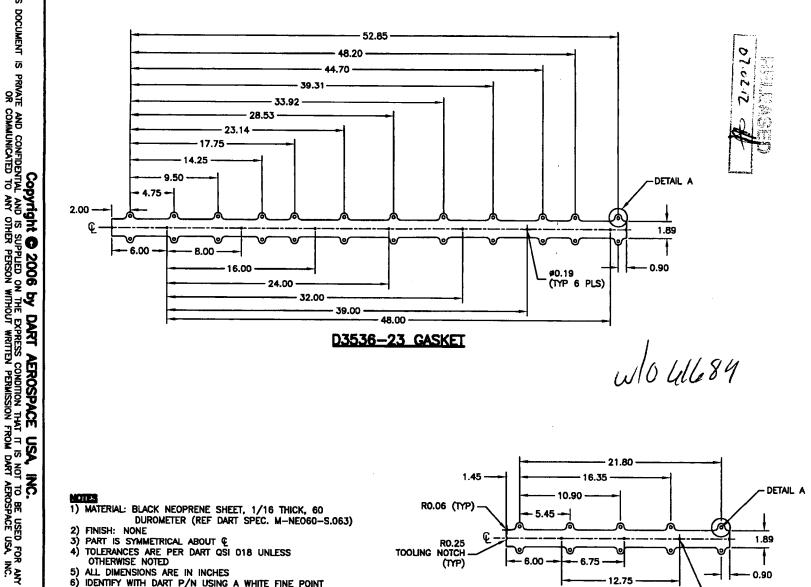






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DATE	STEP	Description of NC			n B	Verification	Approval	Approval
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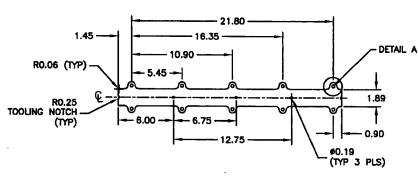
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT €
 4) TOLERANCES ARE PER DART QSI D18 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

W/O:		WORK ORDER CHANGES									
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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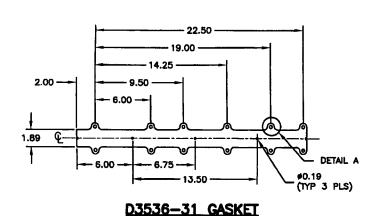
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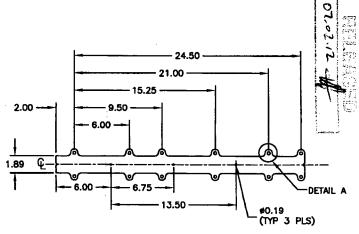
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D3536-33 GASKET



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 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

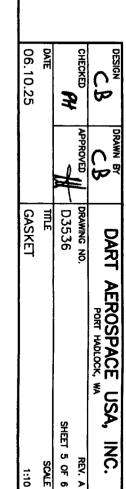
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

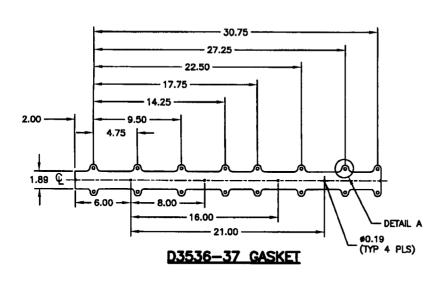
 	
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D3536-35 GASKET

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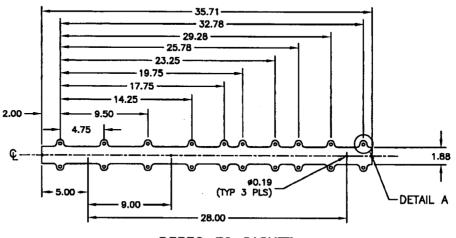
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



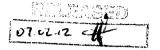
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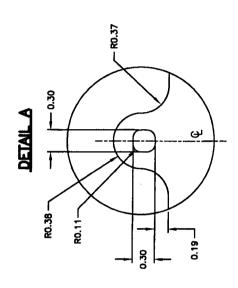
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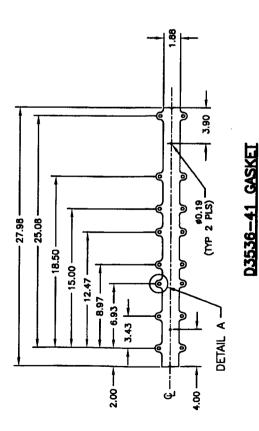
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CHECKED	APPROVED //	DRAWING NO.	REV. A
PH	#	D3536	SHEET 6 OF 6
DATE		TITLE	SCALE
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Approval	Approval			
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